

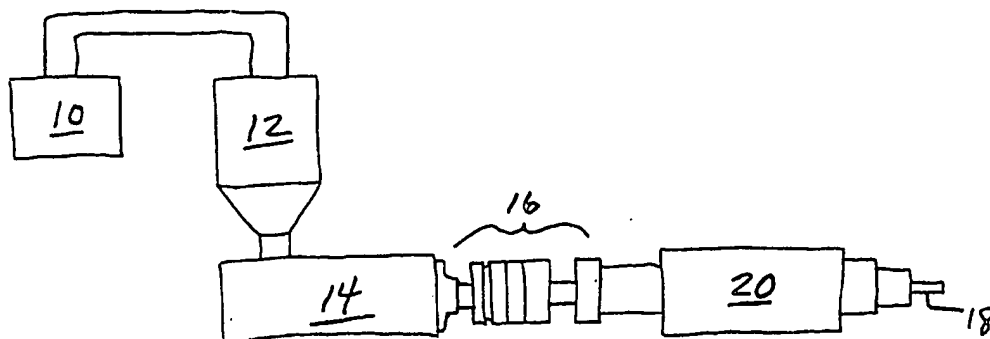
PCT

WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B27N	A2	(11) International Publication Number: WO 98/19838
		(43) International Publication Date: 14 May 1998 (14.05.98)
<p>(21) International Application Number: PCT/US97/19087</p> <p>(22) International Filing Date: 22 October 1997 (22.10.97)</p> <p>(30) Priority Data: 08/735,334 22 October 1996 (22.10.96) US</p> <p>(71) Applicant: CRANE PLASTICS COMPANY LIMITED PARTNERSHIP [US/US]; 2141 Fairwood Avenue, P.O. Box 1047, Columbus, OH 43216 (US).</p> <p>(72) Inventors: ZEHNER, Burch, E.; 1037 Woodtown Drive, Gahanna, OH 43230 (US). BRANDT, Jeffrey, R.; 93 Kingsmeadow Lane, Blacklick, OH 43004 (US).</p> <p>(74) Agent: STANDLEY, Jeffrey, S.; Standley & Gilcrest, Suite 210, 495 Metro Place South, Dublin, OH 43017 (US).</p>		<p>(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, UZ, VN, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</p> <p>Published <i>Without international search report and to be republished upon receipt of that report.</i></p>

(54) Title: RENEWABLE SURFACE FOR EXTRUDED SYNTHETIC WOOD MATERIAL



(57) Abstract

A process is described in which an article of manufacture may be produced which includes a renewable surface on a synthetic wood composite substrate.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TC	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LJ	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

RENEWABLE SURFACE FOR EXTRUDED SYNTHETIC WOOD MATERIAL**BACKGROUND AND SUMMARY OF THE INVENTION**

The present invention relates generally to wood replacement materials. In particular,
5 the present invention relates to a wood-polymer composite material suitable for use in place of
natural wood. The present invention describes a process for manufacturing the composite
materials.

For several reasons, there is a need to find materials that exhibit the look and feel of
natural wood. One reason has to do with the supply of good wood for construction purposes
10 from the world's forests. This supply of wood from mature trees has become an important
issue in recent years and as a result the cost of wood has risen.

Several attempts have been made by others to find a wood like material. Many of
these efforts have failed due to the qualities of the resultant product.

In addition to natural wood, other materials such as particle board, wafer board, and
15 the like may be replaced by the synthetic wood of the present invention. One noticeable
improvement over these materials is that synthetic wood has enhanced moisture resistance.

The present invention overcomes many of the disadvantages of the prior art attempts
at a quality wood replacement material that is capable of being produced in a commercially
practicable production environment. The present invention includes the combining of
20 cellulosic material with a thermoplastic material and optionally with a cross-linking agent to
form a combined product.

In the present invention conventional extrusion equipment is used to fuse the combined
product under sufficient conditions to blend the combined product into a homogeneous

mixture. The mixture of material is extruded through at least one die in a manner described in greater detail hereinafter.

The extruder preferably comprises a hopper to receive and mix the organic fibrous material and the thermoplastic material before being extruded through the die system. In a preferred material composition of the present invention, the synthetic wood material includes approximately two-thirds organic fibrous or cellulosic material and approximately one-third thermoplastic material in combination. The resultant product has an appearance similar to wood and may be sawed, sanded, shaped, turned, fastened and/or finished in the same manner as natural wood. The resultant product is resistant to rot and decay as well as termite attack.

10 The resultant product may be used for example as, decorative moldings inside or outside of a house, picture frames, furniture, porch decks, window moldings, window components, door components, roofing systems, and any other type of use where structural requirements do not exceed the physical properties of the resultant material.

The present invention is useful in a number of different extrusion environments. More particularly, in a preferred embodiment of the present invention, it is useful in conjunction with the synthetic wood composition and method as described in U.S. Patent No. 5,516,472 which issued May 14, 1996 entitled EXTRUDED SYNTHETIC WOOD COMPOSITION AND METHOD FOR MAKING SAME.

15

BRIEF DESCRIPTION OF THE DRAWINGS

20 Figure 1 is a schematic diagram illustrating the process of the present invention;

Figure 2 is a cross-sectional view of a die system of a preferred embodiment of the present invention;

Figure 3 is a schematic representation of another embodiment of the present invention;

Figure 4 is a flow chart of yet another embodiment of the present invention.

DETAILED DESCRIPTION OF PREFERRED EMBODIMENT(S)

The present invention is directed toward synthetic wood extrusions of the type in
5 which synthetic wood material composites are extruded through at least one die. The die may
produce strands of the composite material that flow into a packer or in another embodiment of
the invention, the die may simply produce one flowable homogeneous mass of material into
the packer.

As the strands, in the preferred embodiment, leave the stranding die and enter the
10 packer the material is compressed causing the material to bond to adjacent material strands. In
a packer, the final shape is maintained while the cross linking agents continue to react which
bond the material together along with the individual cellulose molecular chains. The formed
product is then cooled in a cooling tank and transported to an area where it may be cut into
desired lengths.

15 The cellulosic fibrous-polymer composite material used in the present invention may
have a higher cellulosic fiber content than normally recognized. The overall process may
include the mixing of raw materials including cellulosic fibers, thermoplastic materials, cross-
linking agents and process lubricants. The cellulosic material may be any one or more
cellulosic materials such as sawdust, newspapers, alfalfa, wheat pulp, wood chips, wood
20 fibers, wood particles, ground wood, wood flour, wood flakes, wood veneers, wood
laminates, paper, cardboard, straw, cotton, rice hulls, coconut shells, peanut shells, bagass,
plant fibers, bamboo or palm fiber, and kenaf. Cellulosic material is first dried to a low
moisture content. A preferred moisture content is about 1% - 10%.

Thermoplastic materials may include multilayer films, polyethylene, polypropylene, poly-vinyl chloride (PVC), low density polyethylene (LDPE), ethyl-vinyl acetate, other polyethylene copolymers and other thermoplastics.

Examples of cross-linking agents include polyurethanes, such as isocyanate, phenolic
 5 resins, unsaturated polyesters and epoxy resins and combinations of the same. Lubricants may be added as a process aid. Examples of lubricants include zinc stearate or wax. Other materials may be added which are known to the art of extrusion and include accelerators, inhibitors, enhancers, compatibilizers and blowing agents.

Two example formulation recipes are described below:

<u>Recipe A</u>	<u>Amount (parts)</u>
Wood Flour (40/mesh maple)	250
Polyethylene (HDPE)	100
Zinc Stearate	7.5
External Wax	5
Phenolic Resin	15
Isocyanate (MDI)	2.5

10

<u>Recipe B</u>	<u>Amount (parts)</u>
Wood Flour (40/mesh maple)	250
PVC	100
Lubricant (ester)	3
External Wax	4
Process Aids (acrylic)	4
Calcium Stearate	2
Tin Stabilizer	2

In the preferred embodiment of the present invention the cellulosic fiber, thermoplastic raw materials, and other minor ingredients are physically mixed or blended by any conventional mixing device or industrial blender 10. The composition is then placed into a
 15 typical feed hopper 12 as shown in Figure 1. Feed hoppers such as gravity feed or force feed mechanisms (having a crammer) may be used. Once the materials are properly mixed and

transferred to the hopper they are delivered to a heated extruder 14. The preferred process temperature at the extruder is about 325° F. Several well known extruders may be used in the present invention. A twin screw extruder by Cincinnati Milacron (CM80-HP) may be used. In the extruder, the materials are blended and heated and then forced into a die system. The flow rate of the extruder may be between about 150 and 600 pounds per hour. The die system 16 is made up of one or more plates. The die system allows the starting materials to bond and form a shaped-homogeneous product. A typical plate may be made from cast iron and stainless steel material.

In one embodiment the die system is comprised of a plurality of plates nested together to form one continuous die. The first die connected to the extruder is known as an adapter die. Following the adapter die is a transition die. The transition die transforms the combined material discharged from the round stock exiting the adapter die to a shape more generally approaching that of the finished product. Following the transition die is a stranding die. The stranding die plate has multiple apertures which may be substantially round. In a preferred embodiment the stranding die contains apertures which are approximately one-eighth of an inch in diameter. As the material leaves the stranding die it leaves in strands of homogeneous material which are compressed together in a molding die. The molding die is contemplated to take a shape of many common items such as decorative house hold moldings including crown moldings, chair rails, baseboards, door moldings, picture frames, furniture trim, and other products. After passing through the molding die the material enters the setting die where the final shape is maintained. This setting die is also known as the packer. The final shape is maintained yet substantially compressed in overall cross section area. The extruded material 18 is cooled in a cooling chamber 20 and later cut to a required size.

The present invention concerns the addition of a renewable surface onto a synthetic wood material of the type described above. A renewable surface that may be used in the present invention is Enduran™ or mineral filled PBT. A renewable surface allows sanding minor surface damage to restore the original appearance. Standard counter laminates cannot be refurbished in this manner. This renewable surface may be coextruded onto a composite synthetic wood material, which has superior moisture resistance compared to particle board.

In one embodiment of the present invention the coextrusion incorporates a mechanical lock feature 22 which bonds the two materials 24, 26 of the extruded material 18 together. The mechanical lock is best shown in Figure 2. In this case an Enduran™ material 26 has been coextruded onto a cellulosic/polyethylene composite material 24. The composite material is formed with angled pockets 28 to receive the coextruded Enduran™ material thereon. Since the coextrusion process is done under heat the Enduran™ material flows into the pockets and later as the coextrusion cools the Enduran™ material is locked in place within the pockets of the composite material. The pockets preferably include at least one acute angle 30 inside a pocket to enhance the interlock of the two materials.

A second method for accomplishing the combination of the renewable surface and the composite material is to first extrude the composite material 32 and pass it through a roller 34 for an adhesive 36 to be placed on the composite material, as shown in Figure 3. After the adhesive is placed on the material the composite material 32 is passed through a cross head die 38 and a layer 40 of the renewable surface material 42 is added in a conventional hot melt process.

A third method for applying the renewable surface to the composite material is to form two separate extrusion lines. The first line would be for the extrusion 44 of the composite material while the second line would have extrusions 46 of the renewable surface. At a later

point in the process the two materials would be formed together with an adhesive step 48 as shown in Figure 4. The resultant material 50 provides a unique combination of materials not heretofore seen in the art.

5 The above described advantages and features of the present invention are offered as an example of the way in which the present invention may be commercially implemented. The embodiments listed herein are, therefore, exemplary in nature and are not intended to unnecessarily limit the scope of the following claims.

WHAT IS CLAIMED IS:

1. An article of manufacture, comprising:
a composite material comprising cellulosic material of 50-70% by weight, and a thermoplastic of 20% to 40% by weight, coextruded with a renewable surface material.
- 5 2. The article of manufacture claim 1, wherein the renewable surface material flows into pockets formed into the composite material during the coextrusion process.
3. The article of manufacture of claim 1, wherein the renewable surface material is Enduran™.
4. The article of manufacture of claim 1, wherein the cellulosic material is wood
10 flour.
5. The article of manufacture of claim 1, wherein said thermoplastic is polyethylene.
6. The article of manufacture of claim 1, wherein said thermoplastic is PVC.
7. A process for forming a renewable surface on a composite synthetic wood
15 material, the process comprising the steps of:
coextruding a synthetic wood material composition including from 50-70% by weight cellulosic material and from 20% to 40% thermoplastic material with a filled PBT and thermoplastic with an interlocking mechanical bond designed in the synthetic wood and filled with the melt of the PBT.
- 20 8. A process for forming a renewable surface on a composite synthetic wood material, the process comprising the steps of:
extruding a synthetic wood material composition including from 50-70% by weight cellulosic material and from 20% to 40% thermoplastic material;

passing the extruded composite synthetic wood material through a roller to apply adhesive to a surface of the composite synthetic wood material.

passing the extruded composite synthetic wood material having an adhesive on a surface thereof through a cross head die; and

5 applying a hot melt renewable surface material onto said composite synthetic wood material in cross head die.

9. A process for forming a renewable surface onto a composite synthetic wood material, said process comprising the steps of:

 extruding a composite synthetic wood material including 50-70% by weight
10 cellulosic material and 20% to 40% by weight thermoplastic material;

 extruding a renewable surface material;

 bonding the extruded composite synthetic wood material to the extruded renewable surface material with an adhesive.

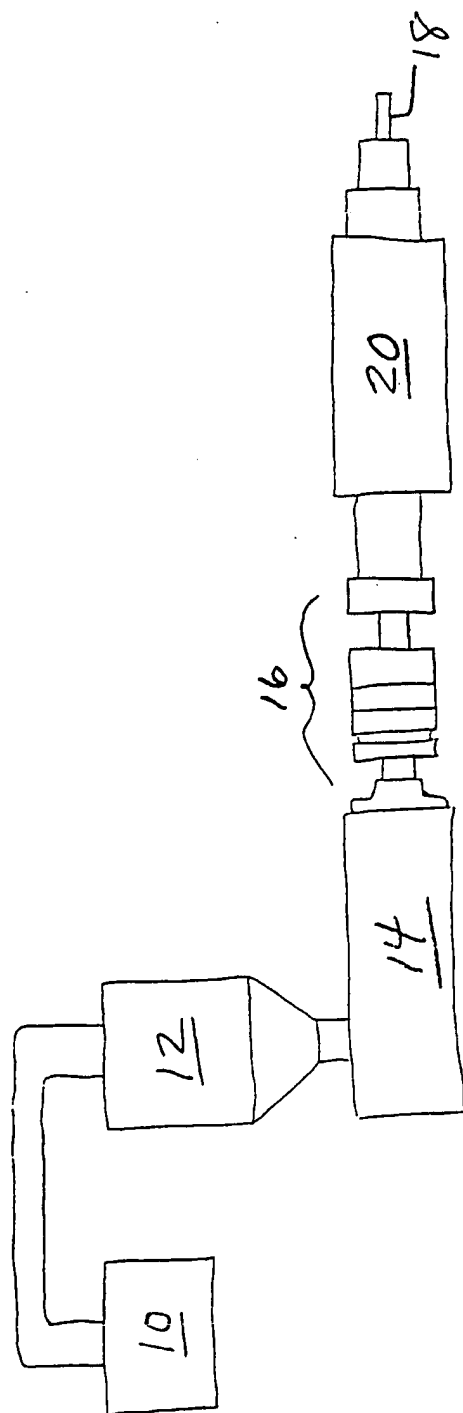


Fig. 1

2/2

